

**A clean version of the amended claims follow:**COPY OF PAPERS  
ORIGINALLY FILED**1. A transportable storage system comprising:**

a multi-layer, flexible, collapsible bladder having a flexible interior layer and a flexible exterior layer;

said interior layer being partially affixed to said exterior layer;

said bladder further having two orifices, one at each end of the bladder;

means to inject and release compressed air, gas or fluid to and from one end of the bladder through the first orifice; and

means to inject and expel liquids or semi-liquids to and from the other end of the bladder through the second orifice.

**3.** The transportable storage system of claim 1, where the interior and exterior layers of said bladder are substantially the same shape and size.

**5.** The transportable storage system of claim 1, where the interior layer is affixed to the exterior layer from the first end of the bladder to the longitudinal circumference of the bladder at or around the latitudinal center of the bladder.

**11.** The transportable storage system of claim 1, wherein the means to inject and release compressed air, gas or fluid comprises a portable air compressor or tank, or pressurized gas or liquid injector engaged with the bladder.

**14.** The transportable storage system of claim 1, wherein said means to inject and expel liquids or semi liquids to and from the bladder further comprises a fuel hose engaged with the bladder.

**16.** A method of manufacture and assembly of a transportable storage system having a bladder with at least two interior layers, and at least one exterior layer, whereby the first interior layer of the bladder is substantially affixed to the exterior

layer, and the second interior layer of the bladder is affixed to the first interior layer at one end of the bladder, the system further having means to create pressure in the first end of the bladder and means to inject liquids into and expel liquids from the second end of the bladder, comprising the following steps:

laying the first layer of the interior of the bladder on a mandrel shaped to the intended ultimate size of the bladder;

laying the second layer of the interior of the bladder on top of said first layer, with a removable material placed between the layers at the second end of the bladder;

laying the exterior layer of the bladder on top of the interior layers of the bladder;

bonding the layers of the bladder by means of pressure and heat;

removing the bladder from the mandrel;

removing the material between the first and second interior layers;

affixing the pressure means to said bladder; and

affixing the liquid injection and expulsion means to said bladder.

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18. The method of manufacture of a transportable storage system of, claims 16 or 17, further comprising the step of winding the second layer of the interior of the bladder with one or more layers of fiber.
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